

Work Order ID 149096

Tuesday, July 19, 2016 2:44:46 PM

149096

Page 1

Item ID: D4636-11 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 7/13/2016 Start Qty: 30.00 ***30*** Cust Item ID:
 Required Date: 7/19/2016 Req'd Qty: 30.00 ***30*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21** Date: **JUL 20 2016** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4636	D								

100 FLOW WATER JET 0.02
100
 Waterjet Memo 0.10
 FLOW CNC Waterjet 1-Cut as per Dwg
 Dwg Rev: D
 Prog Rev: D
 2-Deburr if necessary
 (32) De 11/10/22

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.05
 Quality Control
 (32) De 11/10/22

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.10
 Quality Control
 (32) DAS 38 9-89 JUL 23 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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		OTHER : _____																							

1 490.96

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/13/2016 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 7/19/2016 **Req'd Qty:** 30.00 ***30***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.05

Quality Control

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.05

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.05

DAS
38
9-89

9-89
AUG 17 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

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Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/13/2016 **Start Qty:** 30.00 ***30***

Cust Item ID:

Required Date: 7/19/2016 **Req'd Qty:** 30.00 ***30***

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Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Identify as per dwg & Stock Location: 3115

0.00

190

Packaging

Memo

0.05

Packaging

DAS
6
9-89

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.50

Quality Control

DAS 21 9-89

DAS
21
9-89

AUG 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____									

Picklist Print

Tuesday, July 19, 2016 2:44:46 PM

Page 1

Work Order ID: 149096

149096

Parent Item: D4636-11

D4636-11

Parent Item Name: Bracket

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 12.06.14 NEW ISSUE DD VERF:EC IPP
REV:B 12.11.08 AS PER DWG REV.A DD VERF:JLM IPP REV:C
13.07.17 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	200.3000	0.0376	1.187368			

M6061T6S 080

6061-T6 .080 Sheet

1.2 2/16/07/22

Location

Loc Qty

Loc Code

MAT020

200.3

134217

16.1

m132772

4.3

m133587

7.7

m133828

4.9

m134551

9.3

m134696

48

m134830

21.9

m135147

88.1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

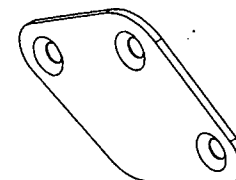
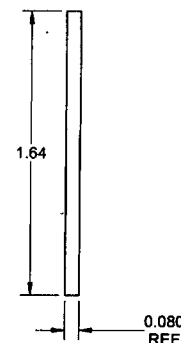
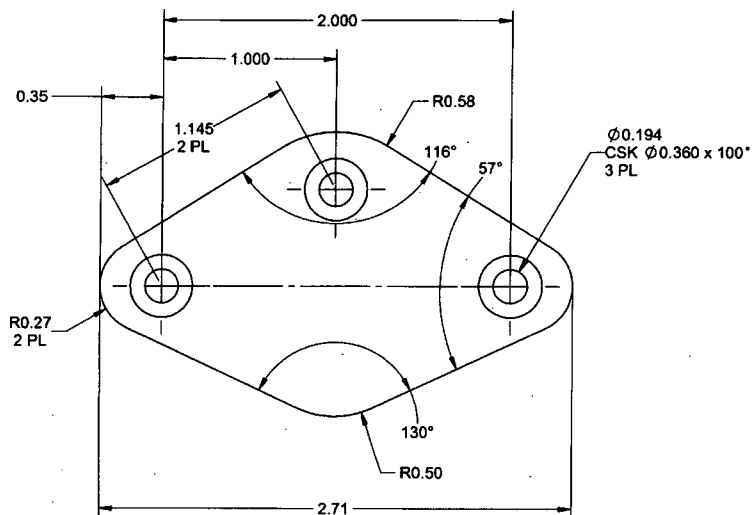
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OTHER : _____									

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO 149096 MJS
1607-20



D4636-11 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

RELEASED
2013-12-23

AS

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D4636	SHEET 7 OF 7
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	BRACKET ASSEMBLY	NTS
DATE	13.12.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	